

Work Order ID 104381

October-24-13 12:54:25 PM

104381

Page 1

Item ID: D3574-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 7/09/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/09/13 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574

Dwg Rev: B

Prog Rev: B

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

3

0

A

13.10.25

3

0

A

13.10.25

Work Order ID 104381

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104381

Page 2

Item ID: D3574-2

Accept:

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protector

Start Date: 7/09/13

Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/09/13

Req'd Qty: 3.00

3

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS
27
9-89

3

120

QC

Memo

0.00

131025

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Debur if necessary.

NA

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 104381

104381

Page 3

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Item ID: D3574-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 7/09/13 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 7/09/13 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>ship</i>	0.00							
150									
Packaging	Memo	0.00				3x			DAS 28 13-10-25 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten signatures and dates:
 13-10-25
 13-10-25

Picklist Print

October-24-13 12:54:25 PM

Page 1

Work Order ID: 104381

Parent Item: D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 7/09/13

Start Qty: 3.00

Required Date: 7/09/13

Required Qty: 3.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04
GE PLASTICS LEXAN SHEET

Purchased

No

sf

2,165.7520

77

Ac 13.10.25

Location

Loc Qty

Loc Code

MAT018

2165.752

124866

286.792

m126425

1878.96

126425 → 77.00

DART AEROSPACE LTD		Work Order:	104381
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.00"	-		V	Jkm-01
7.37	+/-0.030	7.37"	-		T	Jkm-06
10.75	+/-0.030	10.75"	-		T	
11.00	+/-0.030	11.00"	-		T	
15.25	+/-0.030	15.25"	-		T	
25.87	+/-0.030	25.87"	-		T	
39.75	+/-0.030	39.75"	-		T	
44.75	+/-0.030	44.75"	-		T	
53.51	+/-0.030	53.51"	-		T	
63.50	+/-0.030	63.50"	-		T	
65.25	+/-0.030	65.25"	-		T	
10.75	+/-0.030	10.75"	-		T	
11.00	+/-0.030	11.00"	-		T	
14.75	+/-0.030	14.75"	-		T	
25.50	+/-0.030	25.50"	-		T	
25.75	+/-0.030	25.75"	-		T	
26.00	+/-0.030	26.00"	-		T	
32.87	+/-0.030	32.87"	-		T	
38.81	+/-0.030	38.81"	-		T	
45.00	+/-0.030	45.00"	-		T	
48.25	+/-0.030	48.25"	-		T	
58.38	+/-0.030	58.38"	-		T	
61.25	+/-0.030	61.25"	-		T	
64.13	+/-0.030	64.13"	-		T	
64.63	+/-0.030	64.63"	-		T	
66.50	+/-0.030	66.50"	-		T	
7.50	+/-0.030	7.50"	-		T	
9.50	+/-0.030	9.50"	-		T	
10.38	+/-0.030	10.38"	-		T	
10.88	+/-0.030	10.88"	-		T	
14.50	+/-0.030	14.50"	-		T	
16.56	+/-0.030	16.56"	-		T	
18.75	+/-0.030	18.75"	-		T	
24.13	+/-0.030	24.13"	-		T	

DART AEROSPACE LTD		Work Order: 104381
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

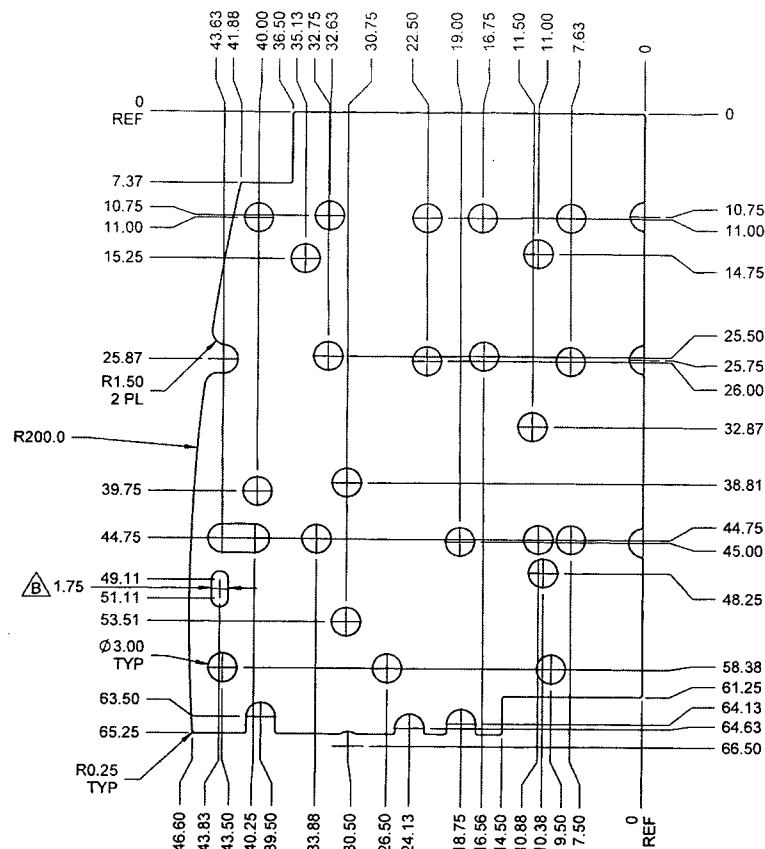
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50"	-		T	Jkm-06
30.50	+/-0.030	30.50"	-		T	
33.88	+/-0.030	33.88"	-		T	
39.50	+/-0.030	39.50"	-		T	
40.25	+/-0.030	40.25"	-		T	
43.50	+/-0.030	43.50"	-		T	
46.60	+/-0.030	46.60"	-		T	
7.63	+/-0.030	7.63"	-		T	
11.00	+/-0.030	11.00"	-		T	
11.50	+/-0.030	11.50"	-		T	
16.75	+/-0.030	16.75"	-		T	
19.00	+/-0.030	19.00"	-		T	
22.50	+/-0.030	22.50"	-		T	
30.75	+/-0.030	30.75"	-		T	
32.63	+/-0.030	32.63"	-		T	
32.75	+/-0.030	32.75"	-		T	
35.13	+/-0.030	35.13"	-		T	
36.50	+/-0.030	36.50"	-		T	
40.00	+/-0.030	40.00"	-		T	
41.88	+/-0.030	41.88"	-		T	
43.63	+/-0.030	43.63"	-		T	
0.125	+/-0.010	0.124"	DAS		V	Jkm-01

Measured by: A
Date: 13.10.25

Audited by: 27 9-89
Date: 13.10.25

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SCRAP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 NO NOTICE
 WORK ORDER
 104381 ML5

13-07-10

RELEASED

B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

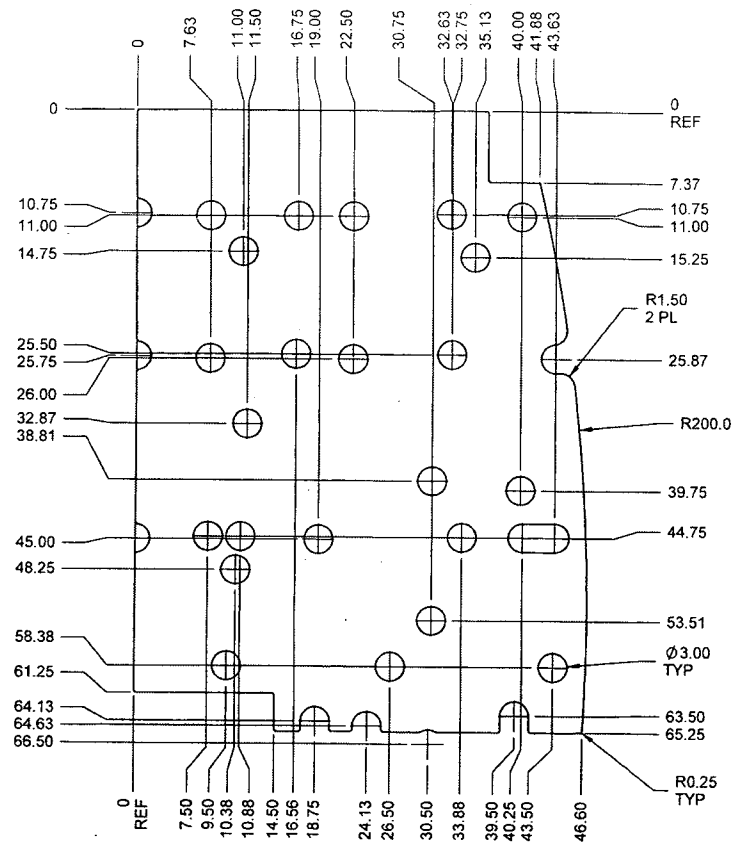
DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
 D3574 SHEET 1 OF 6

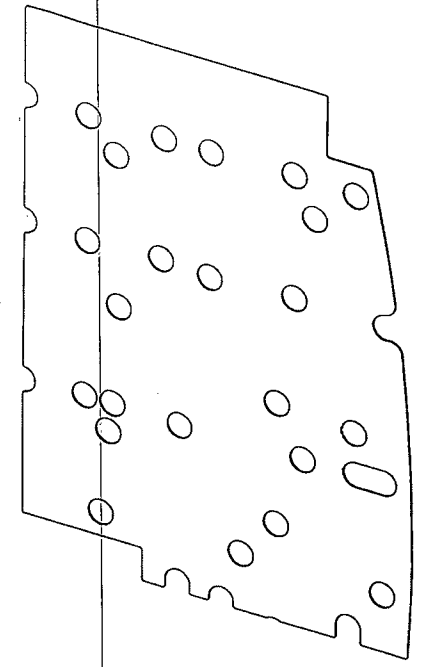
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 CABIN FLOOR PROTECTOR NTS

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D3574-2 CABIN FLOOR PROTECTOR



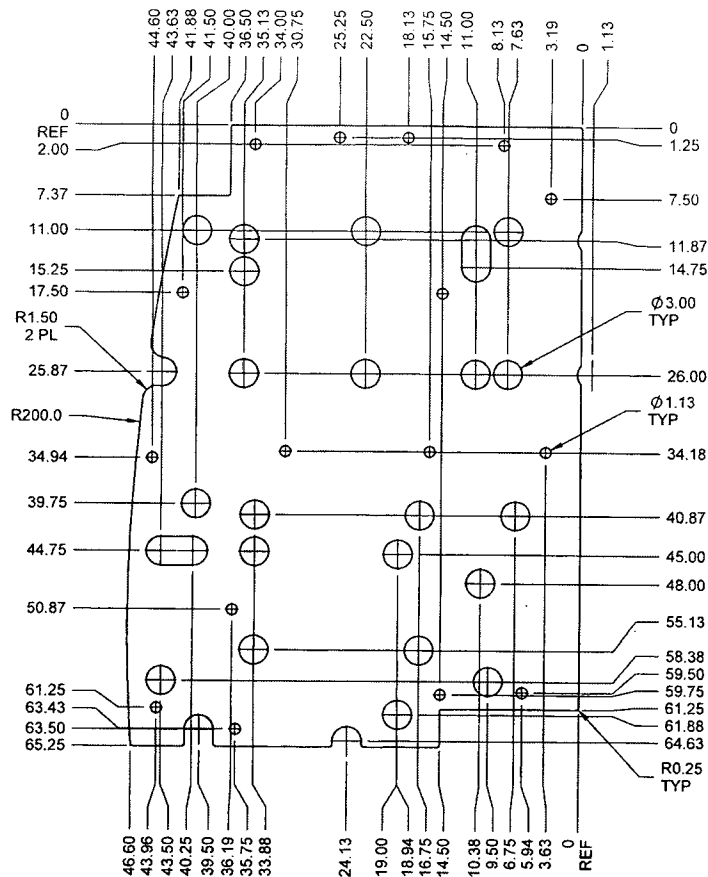
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09/04/01

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

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CHECKED		DRAWING NO.	D3574	REV. B
MFG. APPR.				SHEET 2 OF 6
APPROVED		TITLE	SCALE	
DE APPR.		CABIN FLOOR PROTECTOR		
DATE	09.03.25	NTS		
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D3574-3 CABIN FLOOR PROTECTOR

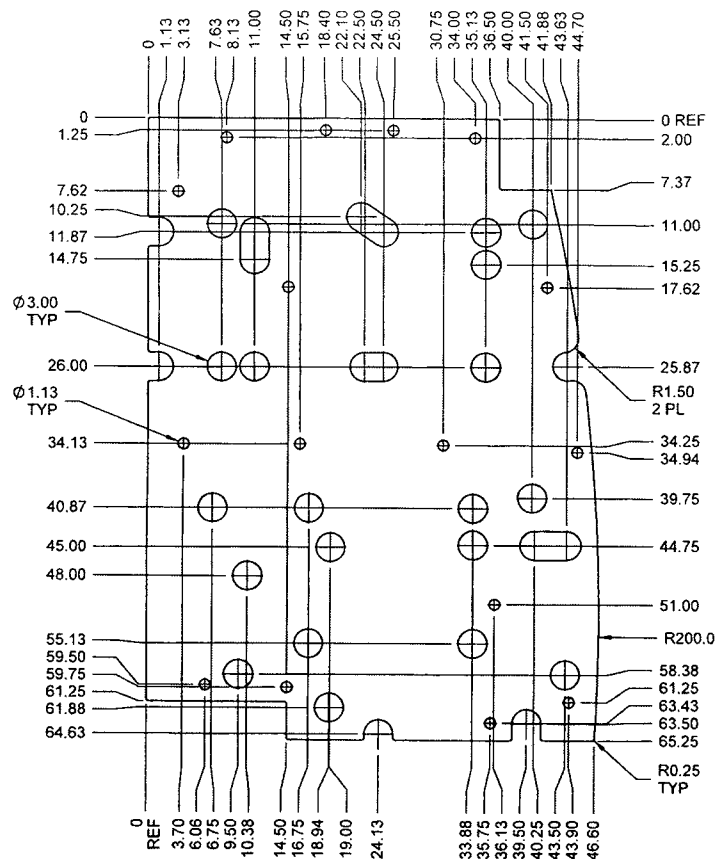
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

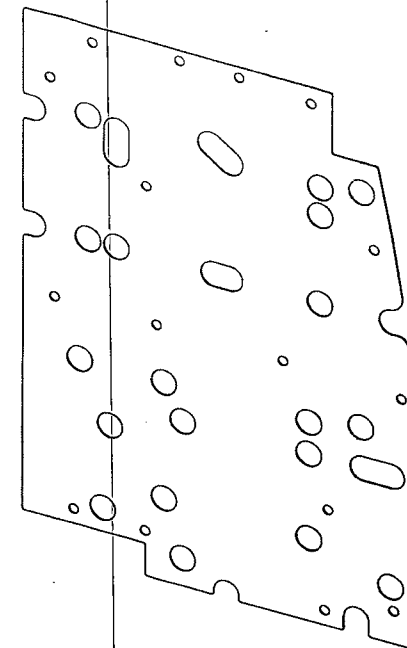
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MFG. APPR.		D3574	SHEET 3 OF 6
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0.125
REF



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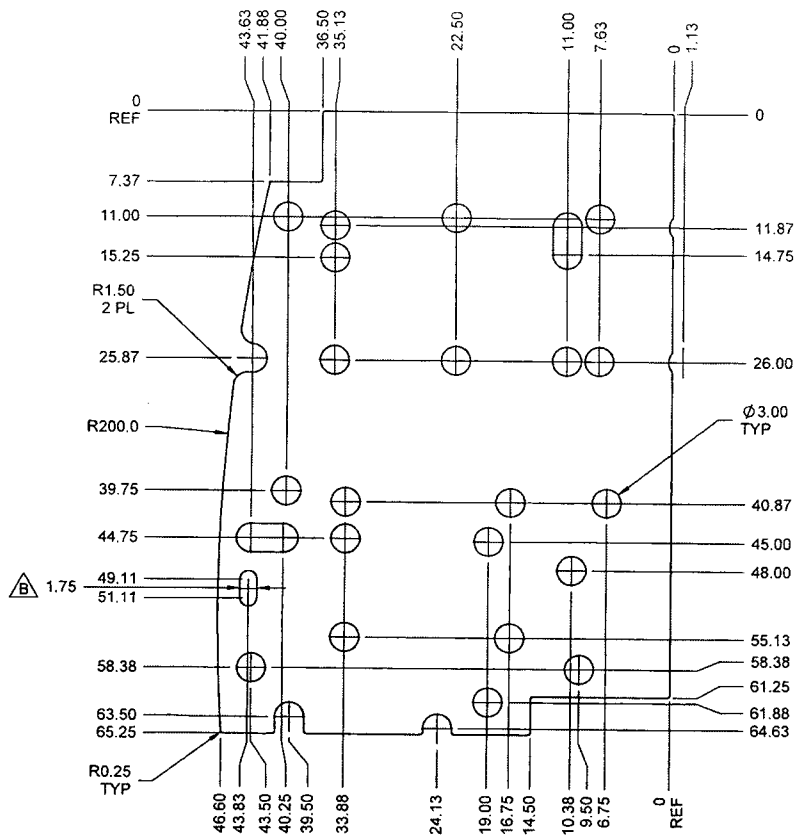
D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

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MFG. APPR.			D3574	SHEET 4 OF 6
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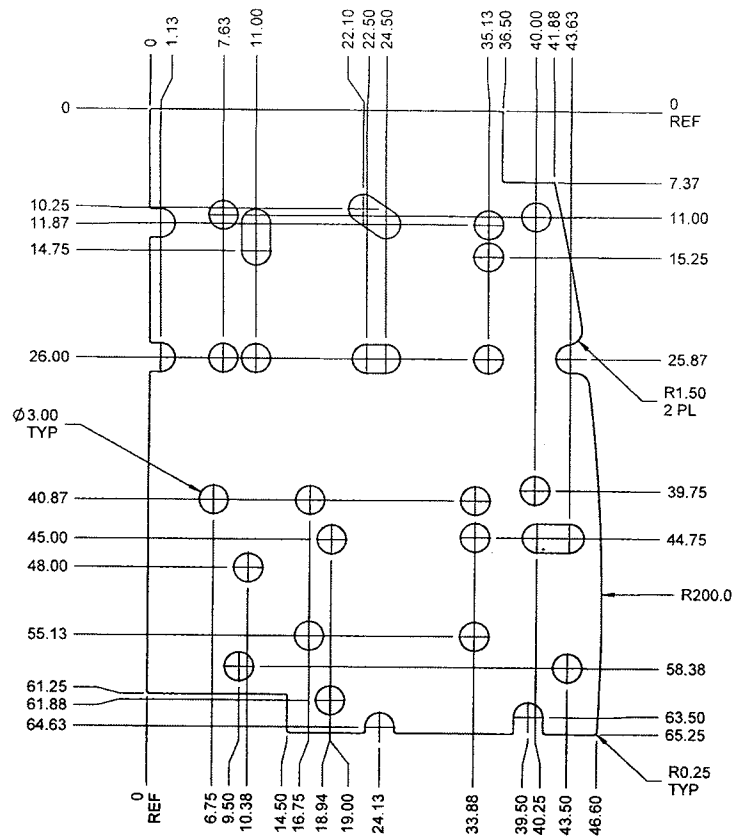
D3574-5 CABIN FLOOR PROTECTOR

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01/04/07 JMB

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
 - 7) WEIGHT: 14.38 lbs
 - 8) CHECK PER TEMPLATE DT8964

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.			SHEET 5 OF 6
APPROVED		TITLE CABIN FLOOR PROTECTOR	SCALE NTS
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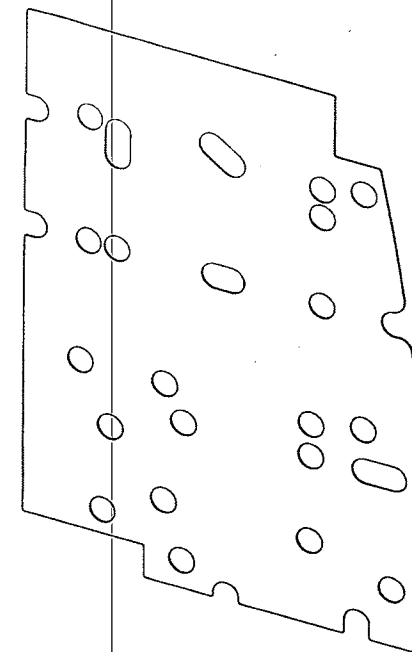
104381



D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.27 lbs
- 8) CHECK PER TEMPLATE DT8965



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